

Work Order ID 77471

December-08-11 8:01:22 AM

\*77471\*

Page 1

Item ID: D2221

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: 350 Basket Base

Stop \*NS2\*

Start Date: 08/12/2011 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 20/12/2011 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: M.L.J Date: 11/12/08 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr                       | Revision Nbr             |                      |         |        |              |               |               |                  |                |
| D2221                          | Rev H                    |                      |         |        |              |               |               |                  |                |

100 Large Fab 0.00

\*100\*

Large Fab

Large Fab

Memo

0.00

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221  
2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221  
3- tack weld mesh on basket as per dwg D2221  
A/R ER316 S.S. Rod Batch: 114649

\*\*\*PLEASE NOTE\*\*\*

IF MAKING -041A OR -043A :  
DRILL HOLES FOR GAS SPRING  
IN D3825-041 AS PER  
DS1 9473

6/11.12.14 1X Ø

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

\*110\*

QC

Quality Control

Memo

0.00

BE  
11.12.14

1 Ø

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Work Order ID 77471****\*77471\***

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December-08-11 8:01:22 AM

Item ID: D2221

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: 350 Basket Base

Start Date: 08/12/2011 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 20/12/2011 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description           | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 120                            | QC6- Inspect dimensions to drawing | 0.00                 |         |        |              |               |               |                  |                |
| <b>*120*</b>                   |                                    |                      |         |        |              |               |               |                  |                |
| QC                             | Memo                               | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |                                    |                      |         |        |              |               |               |                  |                |
| 125                            | Pressure Wash per QSI005 4.3       | 0.00                 |         |        |              |               |               |                  |                |
| <b>*125*</b>                   |                                    |                      |         |        |              |               |               |                  |                |
| HandFinish                     | Memo                               | 0.00                 |         |        |              |               |               |                  |                |
| Hand Finishing                 |                                    |                      |         |        |              |               |               |                  |                |

IXØM 11/12/16

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 77471

**\*77471\***

Page 3

December-08-11 8:01:22 AM

Item ID: D2221 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: 350 Basket Base  
 Start Date: 08/12/2011 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 20/12/2011 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

|     |   |      |  |  |  |  |  |  |  |
|-----|---|------|--|--|--|--|--|--|--|
| 130 | White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel | 0.00 |  |  |  |  |  |  |  |
|-----|---|------|--|--|--|--|--|--|--|

**\*130\***

Powdercoat

Powder Coating

Memo

I - Plug holes prior to

1ST COAT:

START TIME: 11:00

OVEN TEMPERATURE: 400°F

FINISH TIME: 11:30

\*\*\*\*\* 2nd coat if necessary \*\*\*\*\*

2ND COAT:

START TIME: \_\_\_\_\_

OVEN TEMPERATURE: \_\_\_\_\_

FINISH TIME: \_\_\_\_\_

*Handwritten signature and date: 11/12/19*

|     |                          |      |  |  |  |  |  |  |  |
|-----|--------------------------|------|--|--|--|--|--|--|--|
| 140 | QC3- Inspect Part Finish | 0.00 |  |  |  |  |  |  |  |
|-----|--------------------------|------|--|--|--|--|--|--|--|

**\*140\***

QC

Quality Control

Memo

0.00

*Handwritten signature and date: 11-12-19*

*Handwritten note: M119480*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



# Picklist Print

December-08-11 8:01:25 AM

Page 1

Work Order ID: 77471

**\*77471\***

Parent Item: D2221

**\*D2221\***

Parent Item Name: 350 Basket Base

Start Date: 08/12/2011

Required Date: 20/12/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J 05.09.02 Added D3442-1 KJ/JLM  
 IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC  
 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC  
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:EC IPP Rev:N  
 10.06.29 added pressure wash DD verf:EC

| Component Item ID/<br>Item Name    | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D2221-1<br><b>*D2221-1*</b><br>Rib |                        | Manufactured  | No          |                     |                  | 100             | Each               | 16.0000        | 1           | 1            |               |                |        |

\*\*

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA006    | 16      |          |
| 71372    | 4       |          |
| 72297    | 12      |          |

D2221-5  
**\*D2221-5\***  
Rib

Manufactured No

100 Each 12.0000 2 2

\*\*

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA006    | 12      |          |
| 67117    | 2       |          |
| 71218    | 10      |          |

D2221-7  
**\*D2221-7\***  
Rib

Manufactured No

100 Each 8.0000 1 1

\*\*

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA006    | 8       |          |
| 71219    | 1       |          |
| 72731    | 3       |          |
| 73203    | 4       |          |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

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Page 2

Work Order ID: 77471

**\*77471\***

Parent Item: D2221

**\*D2221\***

Parent Item Name: 350 Basket Base

Start Date: 08/12/2011

Required Date: 20/12/2011

Start Qty: 1.00

Required Qty: 1.00

D2232-3 Manufactured No

**\*D2232-3\***

Basket Hinge

100 Each 16.0000 2 2

\*\*

Location

Loc Qty

Loc Code

WA005

16

75581

16

B 72925 → 5

D2235-1 Manufactured No

**\*D2235-1\***

Basket Rib

100 Each 13.0000 2 2

\*\*

Location

Loc Qty

Loc Code

WA005

13

66895

4

73200

9

2

D2581 Manufactured No

**\*D2581\***

Mounting Bracket

100 Each 32.0000 2 2

\*\*

Location

Loc Qty

Loc Code

WA005

32

69739

2

70766

2

73762

3

75280

25

5

D3442-1 Manufactured No

**\*D3442-1\***

Shim

100 Each 19.0000 2 2

\*\*

Location

Loc Qty

Loc Code

WA005

19

871224

4

71783

15

2

December-08-11 8:01:25 AM

Shop Packet Print

Page 2

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

# Picklist Print

December-08-11 8:01:25 AM

Page 3

Work Order ID: 77471

**\*77471\***

Parent Item: D2221

**\*D2221\***

Parent Item Name: 350 Basket Base

Start Date: 08/12/2011

Required Date: 20/12/2011

Start Qty: 1.00

Required Qty: 1.00

D3825-041

Manufactured No

100

Each

6.0000

2

2

**\*D3825-041\***

Rib Assembly (Basket End)

\*\*

*Pl 11.12.12*

Location

Loc Qty

Loc Code

WA006

6

72727

6

100

Each

6.0000

2

2

\*\*

*Pl 11.12.12*

D3826-041

Manufactured No

**\*D3826-041\***

Rib / Gusset Assembly

Location

Loc Qty

Loc Code

WA

4

72728

4

WA006

2

73749

2

100

Each

9.0000

1

1

\*\*

*Pl 11.12.12*

D3827-041

Manufactured No

**\*D3827-041\***

Rib Assembly (Inboard)

Location

Loc Qty

Loc Code

WA006

9

72083

3

72729

6

100

Each

2.0000

1

1

\*\*

*Pl 11.12.12*

D3832-1

Manufactured No

**\*D3832-1\***

Mesh (Base)

Location

Loc Qty

Loc Code

WA006

2

72702

2

December-08-11 8:01:25 AM

Shop Packet Print

Page 3

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 77471

**\*77471\***

Parent Item: D2221

**\*D2221\***

Parent Item Name: 350 Basket Base

Start Date: 08/12/2011

Required Date: 20/12/2011

Start Qty: 1.00

Required Qty: 1.00

D3833-1

Manufactured No

100

Each

8.0000

2

2

**\*D3833-1\***

Mesh (Base End Face)

\*\*

*CP 11-12-12*

Location

Loc Qty

Loc Code

WA

8

70470

6

71834

72866

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

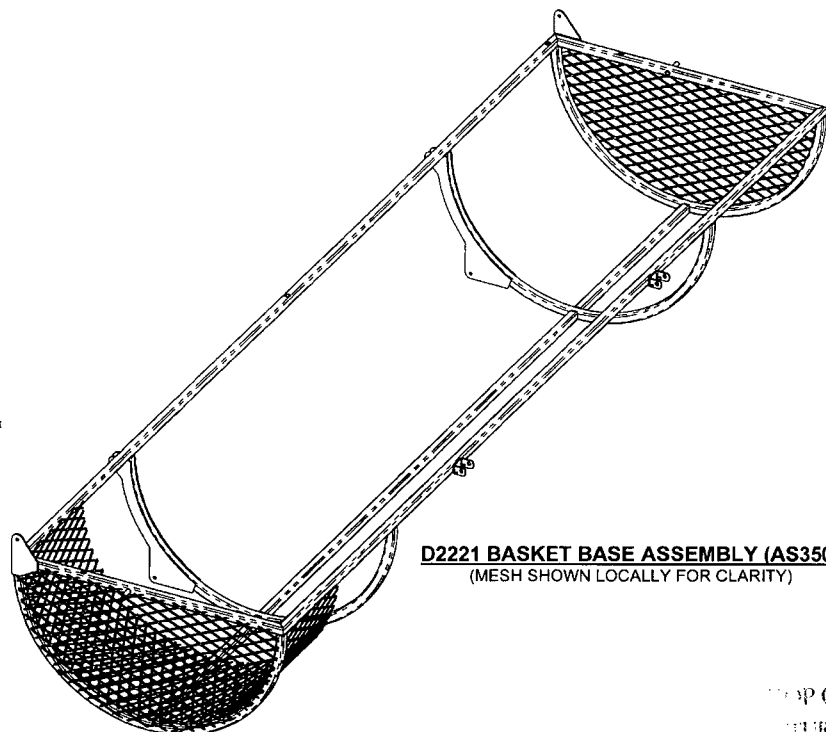
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries





**D2221 BASKET BASE ASSEMBLY (AS350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

TOP COPY  
RETURN TO  
ENGINEERING  
CONTROLLED COPY  
NOT TO AMEND  
WITHOUT NOTICE  
WORK ORDER  
77471 M.C.J  
11/12/08

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING

| ITEM | QTY | P/N       | DESCRIPTION                  |
|------|-----|-----------|------------------------------|
| 1    | X   | D2221     | BASKET BASE ASSEMBLY (AS350) |
| 2    | 1   | D2221-1   | RIB                          |
| 3    | 2   | D2221-5   | RIB                          |
| 4    | 1   | D2221-7   | RIB                          |
| 5    | 2   | D2232-3   | BASKET HINGE                 |
| 6    | 2   | D2235-1   | RIB                          |
| 7    | 2   | D2581     | MOUNTING BRACKET             |
| 8    | 2   | D3442-1   | SHIM                         |
| 9    | 2   | D3825-041 | RIB ASSY (BASKET END)        |
| 10   | 2   | D3826-041 | RIB/GUSSET ASSY              |
| 11   | 1   | D3827-041 | RIB ASSY (INBOARD)           |
| 12   | 2   | D3833-1   | MESH, BASE END FACE          |
| 13   | 1   | D3832-1   | MESH (BASE)                  |

RELEASED  
08/11/18

|            |   |   |              |
|------------|---|---|--------------|
| H          | REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/-5/-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2227-3; D3826-041 REPLACES D2235-1/D2235; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM. | MB  | 08.09.18     |
| G          | MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT   | AJS   | 08.06.16     |
| F          | ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET  | PH  | 05.06.07     |
| E          | CHANGE HINGE  | CP  | 01.04.19     |
| D          | CHANGE LATCH  | BW  | 96.06.21     |
| C          | SEPARATE BASKET AND LID   | KH  | 95.11.21     |
| REV.       | DESCRIPTION   | BY  | DATE         |
| DESIGN     | BW  | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA  |              |
| DRAWN      | JS  |   |              |
| CHECKED    | JS  | DRAWING NO.   | REV. H       |
| MFG. APPR. | JS  | D2221   | SHEET 1 OF 5 |
| APPROVED   | JS  | TITLE   | SCALE        |
| DE APPR.   | JS  | BASKET BASE ASSEMBLY (350)  | NTS          |
| DATE       | 08.09.18  | <small>COPYRIGHT © 1994 BY DART AEROSPACE LTD<br/> THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> |              |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

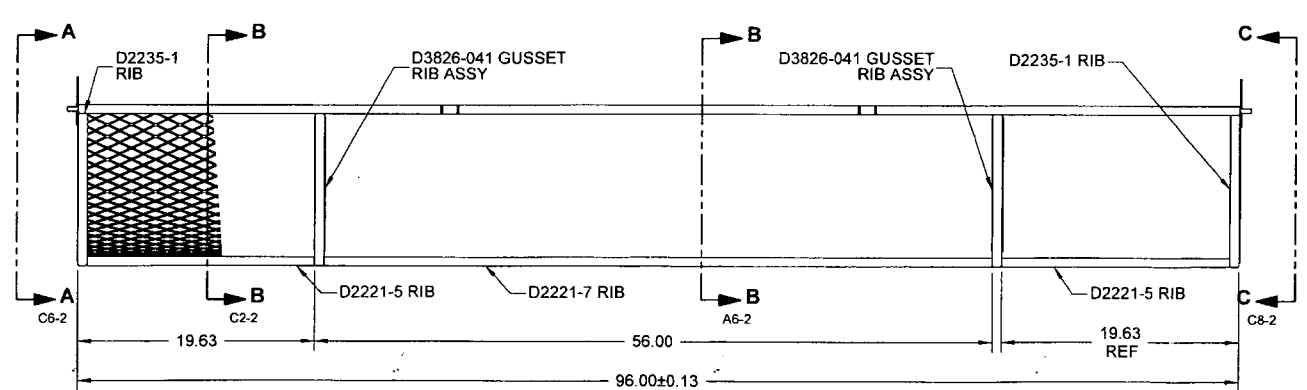
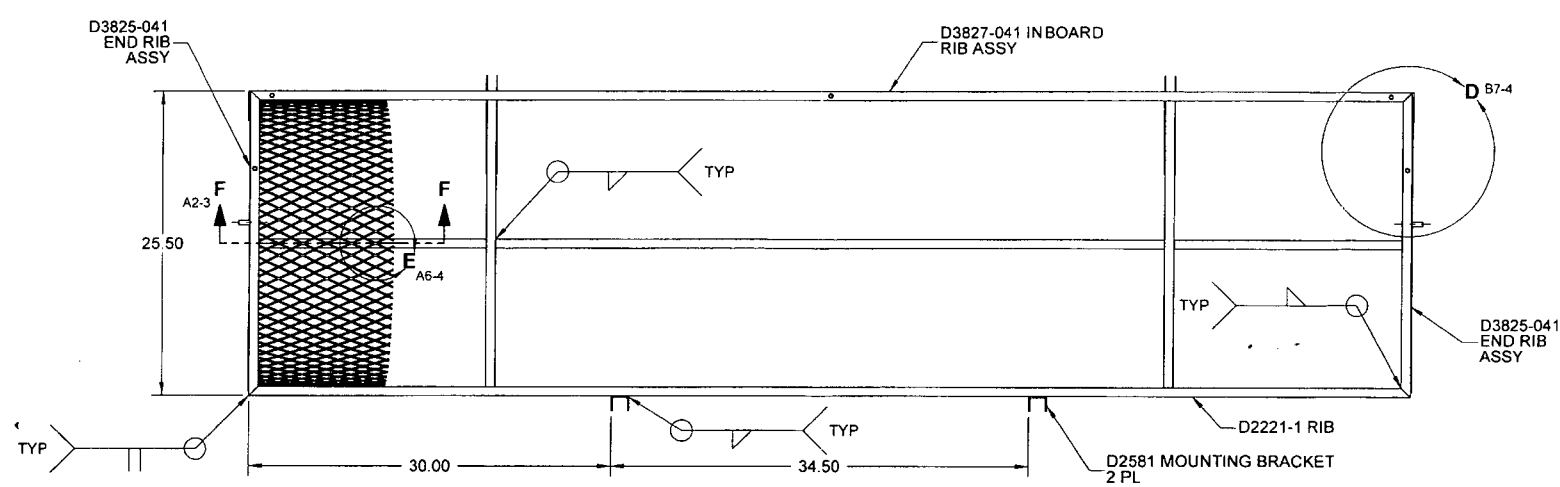
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
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
**NOTE:** Date & initial all entries

77471



**D2221 BASKET BASE ASSEMBLY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**RELEASED**  
06/11/18 NED

|   |   |  |              |
|---|---|--|--------------|
| DESIGN  | BW  | <b>DART AEROSPACE LTD</b>              |              |
| DRAWN   |   | HAWKESBURY, ONTARIO, CANADA            |              |
| CHECKED   |  | DRAWING NO.                            | REV. H       |
| MFG. APPR.  |   | D2221                                  | SHEET 2 OF 5 |
| APPROVED  |  | TITLE                                  | SCALE        |
| DE APPR.  |   | <b>BASKET BASE ASSEMBLY (350)</b>      | NTS          |
| DATE  | 08.09.18  | COPYRIGHT © 1994 BY DART AEROSPACE LTD |              |
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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

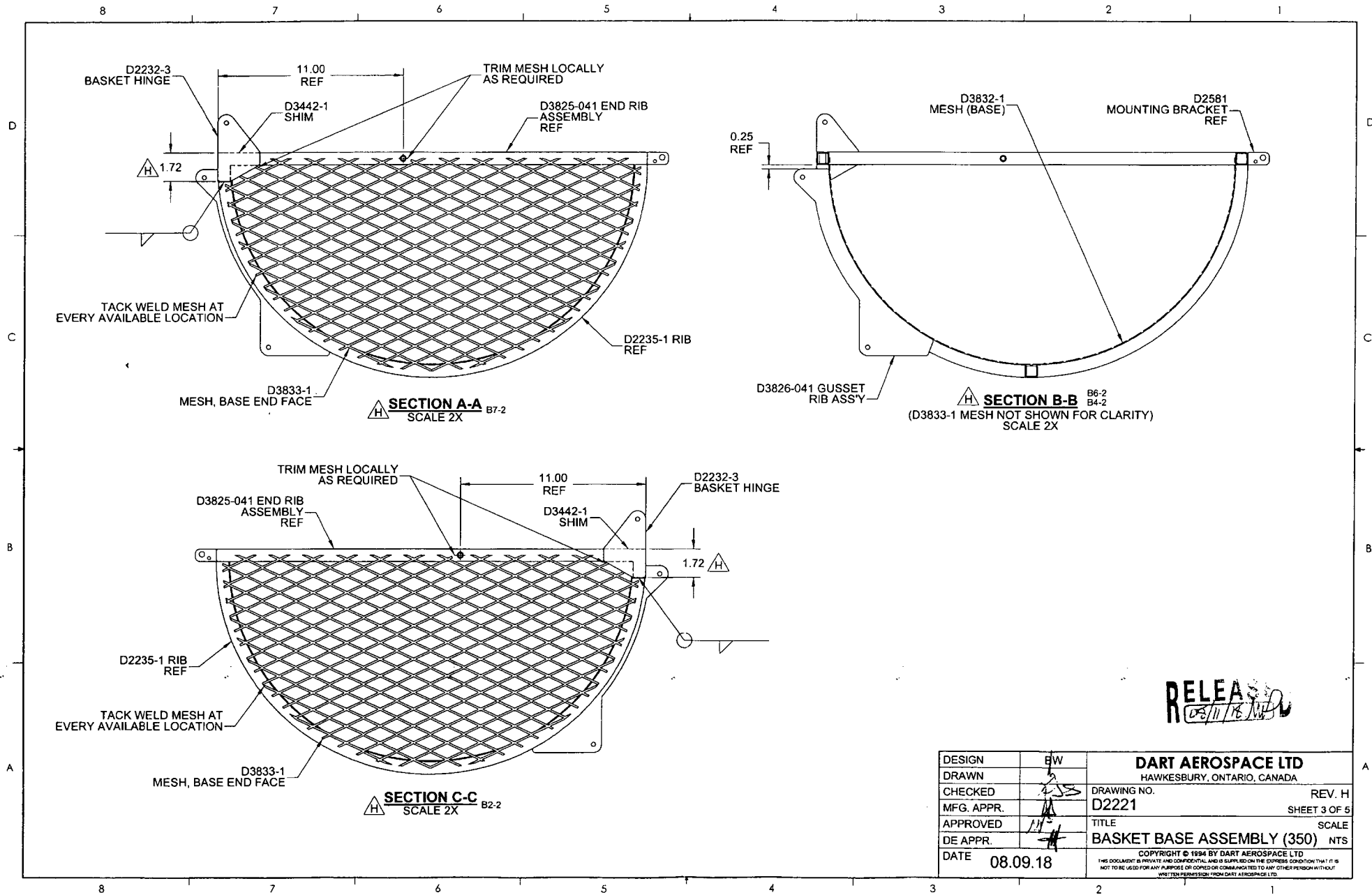
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

77471



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|            |          |   |              |
|------------|----------|---|--------------|
| DESIGN     | BW       | <b>DART AEROSPACE LTD</b>   |              |
| DRAWN      |          | HAWKESBURY, ONTARIO, CANADA   |              |
| CHECKED    | JS       | DRAWING NO.   | REV. H       |
| MFG. APPR. |          | D2221   | SHEET 3 OF 5 |
| APPROVED   | PH       | TITLE   | SCALE        |
| DE APPR.   |          | BASKET BASE ASSEMBLY (350)  | NTS          |
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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
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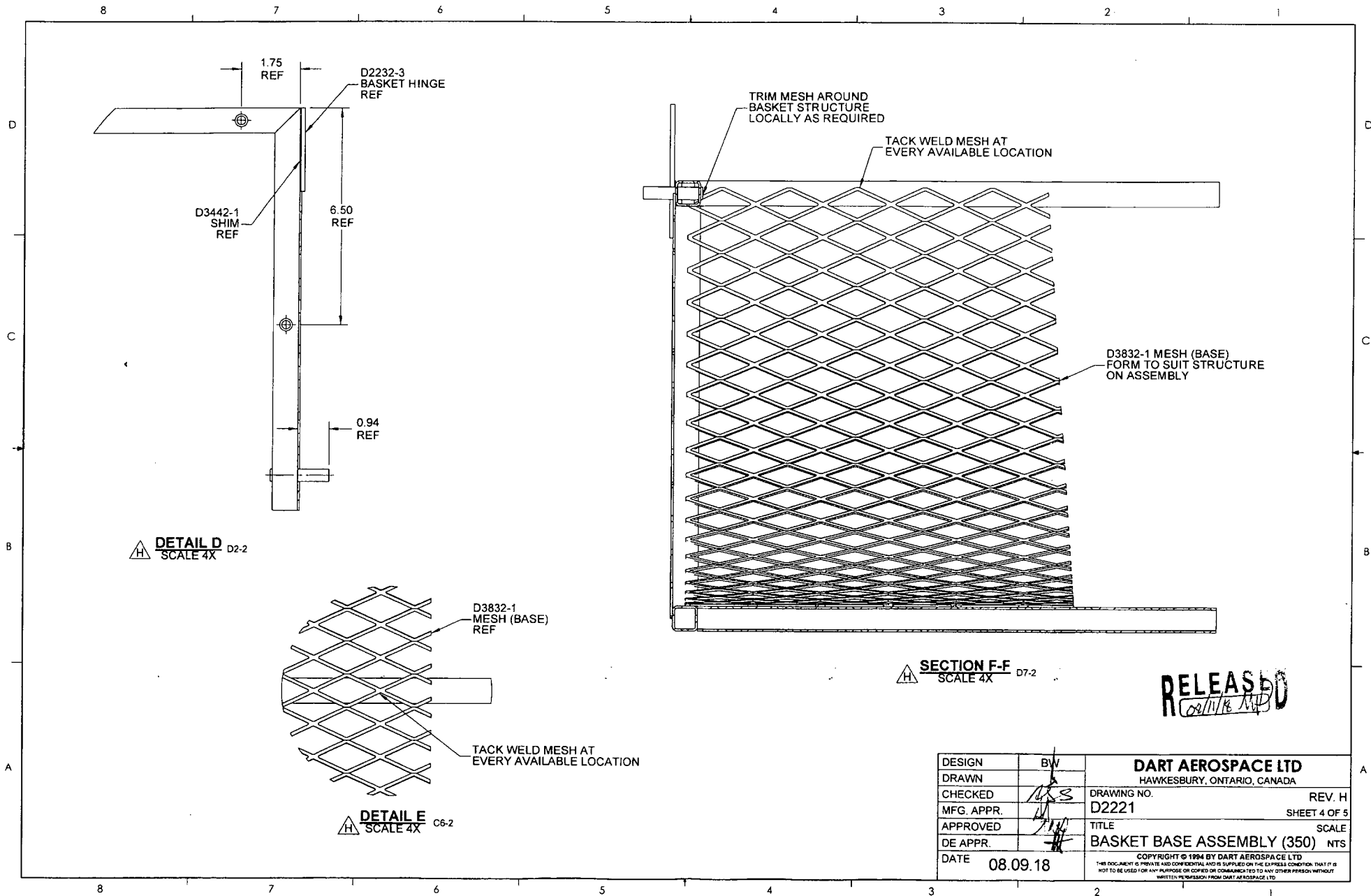
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

77471



RELEASED  
20/11/16 MP

|            |          |   |        |
|------------|----------|---|--------|
| DESIGN     | BW       | <b>DART AEROSPACE LTD</b>   |        |
| DRAWN      | AS       | HAWKESBURY, ONTARIO, CANADA   |        |
| CHECKED    | AS       | DRAWING NO. D2221   | REV. H |
| MFG. APPR. | AS       | SHEET 4 OF 5  |        |
| APPROVED   | AS       | SCALE   |        |
| DE APPR.   | AS       | BASKET BASE ASSEMBLY (350) NTS  |        |
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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

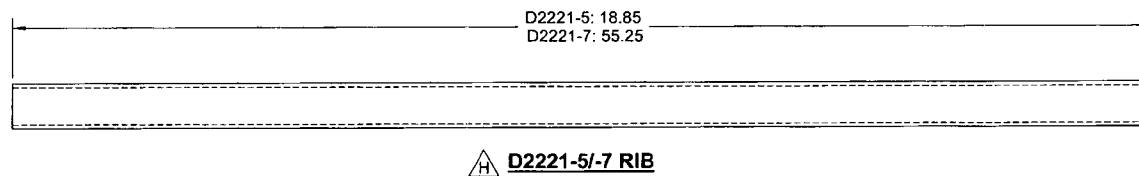
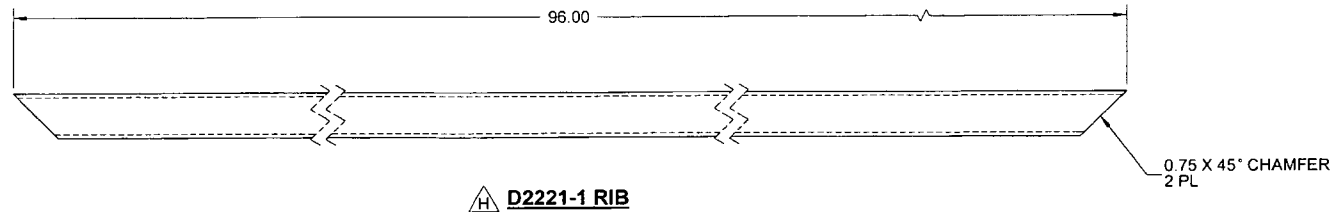
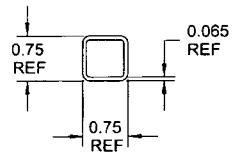
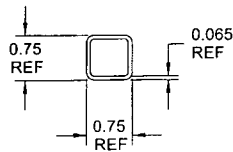
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



77471



- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL REF. DART SPEC. M304TS0.750W0.065
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

|            |          |  |        |
|------------|----------|--|--------|
| DESIGN     | BW       | <b>DART AEROSPACE LTD</b>  |        |
| DRAWN      |          | HAWKESBURY, ONTARIO, CANADA  |        |
| CHECKED    |          | DRAWING NO. D2221  | REV. H |
| MFG. APPR. |          | SHEET 5 OF 5   |        |
| APPROVED   |          | TITLE  | SCALE  |
| DE APPR.   |          | BASKET BASE ASSEMBLY (350) NTS   |        |
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RELEASED  
08/11/18

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# DART SERVICE INSTRUCTION

TO AMEND DRAWING D350-607 REV. F OR SUBSEQUENT APPROVED REVISION

REF CANADIAN STC: SH94-14

FAA STC: SR00213NY

EASA STC: EASA.IM.R.S.01405

THE PURPOSE OF THIS DART SERVICE INSTRUCTION (DSI), IS TO PROVIDE OPERATORS OF AS350 / 355 ROTORCRAFT EQUIPPED WITH DART D350-607-041 HELI UTILITY BASKETS WITH AN UPGRADE KIT TO REPLACE THE EXISTING LID PROP ARM WITH 2 GAS SPRINGS.

FOR OPERATORS EQUIPPED WITH D350-607-043/-045/-047 HELI UTILITY BASKETS THIS DSI WILL PROVIDE AN UPGRADE KIT TO REPLACE THE EXISTING LID PROP ARM WITH 1 GAS SPRING.

| ITEM No. | QTY -141 | QTY -143 | QTY -145 | PART NUMBER   | DESCRIPTION   |
|----------|----------|----------|----------|---------------|---|
| 1        | X        |          |          | D350-607-141  | AUTOMATIC LID OPENER INSTL (FOR USE ON -041 BASKET*)      |
| 2        |          | X        |          | D350-607-143  | AUTOMATIC LID OPENER INSTL (FOR USE ON -043/-047 BASKET*) |
| 3        |          |          | X        | D350-607-145  | AUTOMATIC LID OPENER INSTL (FOR USE ON -045 BASKET*)      |
| 4        | 2        |          | 1        | D3953-1       | GAS SPRING BRACKET  |
| 5        | 2        | 1        | 1        | D3953-3       | GAS SPRING STUD (LID)                                     |
| 6        | 2        | 1        | 1        | D3953-5       | GAS SPRING STUD (BASE)                                    |
| 7        | 2        | 1        | 1        | D3953-7       | GAS SPRING SPACER   |
| 8        | 4        | 2        | 2        | D3953-9       | GAS SPRING WASHER   |
| 9        | 2        | 1        | 1        | D3953-11      | GAS SPRING SPACER   |
| 10       | 2        |          | 1        | D3953-13      | GAS SPRING SPACER   |
| 11       |          | 1        |          | D3953-15      | GAS SPRING BRACKET  |
| 12       |          | 1        |          | D3953-17      | GAS SPRING SPACER   |
| 13       | 2        | 1        | 1        | D3969-1       | GAS SPRING  |
| 14       | 4        | 2        | 2        | AN3C11A       | BOLT  |
| 15       |          | 2        |          | AN3C15A       | BOLT  |
| 18       | 4        |          | 2        | AN3C16A       | BOLT  |
| 19       | 4        | 2        | 2        | AN310-4       | CASTELLATED NUT   |
| 20       | 8        | 4        | 4        | MS21043-3     | NUT   |
| 21       | 4        | 2        | 2        | MS24665-212   | COTTER PIN  |
| 22       | 8        | 4        | 4        | NAS1149C0332R | WASHER (OR AN960C10L)                                     |
| 23       | 4        | 2        | 2        | NAS1149C0432R | WASHER (OR AN960C416L)                                    |

**\*NOTE:** FOR CUSTOMERS WISHING TO ORDER NEW BASKETS WITH THE LID OPENER PRE-INSTALLED USE THE FOLLOWING NUMBERS:



D350-607-041 BASKET WITH AUTOMATIC LID OPENER INSTALLED = D350-607-041A  
D350-607-043 BASKET WITH AUTOMATIC LID OPENER INSTALLED= D350-607-043A  
D350-607-045 BASKET WITH AUTOMATIC LID OPENER INSTALLED = D350-607-045A  
D350-607-047 BASKET WITH AUTOMATIC LID OPENER INSTALLED = D350-607-047A

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY:   
D. SHEPHERD (DE # 02)

DATE: 09.11.11  
CERT. NO.: SH94-14  
ISSUE NO.: 4

|            |   |  |              |
|------------|---|--|--------------|
| C          | SHEET 1 PL, -143 INSTL, ITEM 6 QTY WAS 2, ITEM 7 WAS 0.   | AJS  | 09.11.11     |
| B          | SHT 1 P/L ITEM 22 WAS NAS1149C0332 ITEM 23 WAS NAS1149C0432H. ALL OTHER SHEETS UPDATED ACCORDINGLY. (REASON: DRAFTING ERROR) INSTALLATIONS RENAMED. | AJS  | 09.11.06     |
| A          | NEW ISSUE   | AJS  | 09.09.15     |
| REV.       | DESCRIPTION   | BY   | DATE         |
| DESIGN     | AJS   | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA   |              |
| DRAWN      | AJS   |  |              |
| CHECKED    |    | DRAWING NO.  | REV. C       |
| MFG. APPR. | N/A   | DSI 9473   | SHEET 1 OF 8 |
| APPROVED   |    | TITLE  | SCALE        |
| DE APPR.   |   | AUTOMATIC LID OPENER INSTL   | NTS          |
| DATE       | 09.11.11  | COPYRIGHT © 2009 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. |              |

FOR D350-607-041 BASKETS, REPLACE THE EXISTING D2332-041 PROP ARM ASSEMBLY AS FOLLOWS:

### **D350-607-141 AUTOMATIC LID OPENER INSTALLATION**

**NOTE:** ONCE THIS MODIFICATION IS COMPLETE YOU WILL NOT BE ABLE TO RE-INSTALL THE D2332-041 PROP ARM.




- 1) REMOVE THE D2332-041 PROP ARM.
- 2) GRIND FLUSH THE D2327-3 SPACER BUSHING ON BOTH ENDS OF THE BASKET AS SHOWN IN FIGURE 1 (IT IS PERMISSIBLE TO GRIND ALL 4 SPACERS FLUSH). TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4.
- 3) LOCATE THE D3953-1 GAS SPRING BRACKET AS SHOWN IN FIGURE 1. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET LID SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL A. INSTALL THE D3953-1 GAS SPRING BRACKET & D3953-13 GAS SPRING SPACER USING 2X AN3C16A BOLT, 2X NAS1149C0332R WASHER & 2X MS21043-3 NUT AS SHOWN IN VIEW E-E.
- 4) LOCATE THE D3953-5 GAS SPRING STUD AS SHOWN IN FIGURE 1. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET BASE SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL B. FASTEN D3953-5 IAW VIEW F-F USING 2X AN3C11A BOLT, 2X NAS1149C0332R WASHER & 2X MS21043-3 NUT.
- 5) INSTALL 1X D3953-11 GAS SPRING SPACER ONTO THE D3953-5 STUD AS SHOWN IN VIEW F-F. INSTALL THE LARGE END OF THE D3969-1 GAS SPRING SPRING ONTO THE D3953-5 GAS SPRING STUD AND FASTEN IN PLACE USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432R WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW F-F. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.
- 6) INSERT THE D3953-3 GAS SPRING STUD INTO THE D3953-1 GAS SPRING BRACKET & INSERT THE D3953-7 GAS SPRING SPACER ONTO THE D3953-3 GAS SPRING AS SHOWN IN VEW E-E. RAISE THE BASKET LID AND INSTALL THE ROD END OF THE D3969-1 GAS SPRING ONTO THE D3953-3 GAS SPRING STUD USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432R WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW E-E. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.

**NOTE:** THE D3953-3 GAS SPRING STUD CAN BE HELD IN PLACE WITH A  $\frac{9}{16}$  OPEN END SPANNER / WRENCH.

**NOTE:** WITH THE LID IN THE CLOSED POSITION THE GAS SPRING SHOULD NOT BE FULLY COMPRESSED.

- 7) REPEAT STEPS 2 THROUGH 6 AT THE OTHER END OF THE BASKET.
- 8) TEST THE INSTALLATION. IF INSTALLED PROPERLY THE GAS SPRINGS SHOULD ASSIST THE BASKET USER IN BOTH OPENING AND CLOSING THE BASKET LID.

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| DRAWN      | AJS   |   |              |
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| MFG. APPR. | N/A   | DSI 9473  | SHEET 2 OF 8 |
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FOR D350-607-043/-047 BASKETS REPLACE THE EXISTING D2332-041 PROP ARM ASSEMBLY AS FOLLOWS:

### **D350-607-143 AUTOMATIC LID OPENER INSTALLATION**

**NOTE:** THIS KIT MAY BE INSTALLED AT EITHER END OF THE BASKET. HOWEVER, THE PROP ARM MUST BE REMOVED IN EITHER CASE AS IT WILL INTERFERE WITH THE FUNCTION OF THE GAS SPRING.

- 1) REMOVE THE D2332-041 PROP ARM.
- 2) GRIND FLUSH THE D2327-3 SPACER BUSHING ON THE END OF THE BASKET WHERE THE LID OPENER IS BE INSTALLED AS SHOWN IN FIGURE 2 (IT IS PERMISSIBLE TO GRIND ALL 4 SPACERS FLUSH). TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4.
- 3) LOCATE THE D3953-15 GAS SPRING BRACKET AS SHOWN IN FIGURE 2. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET LID SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL C. INSTALL THE D3953-15 GAS SPRING BRACKET & D3953-17 GAS SPRING SPACER USING 2X AN3C15A BOLT, 2X NAS1149C0332R WASHER & 2X MS21043-3 NUT AS SHOWN IN VIEW G-G.
- 4) LOCATE THE D3953-5 GAS SPRING STUD AS SHOWN IN FIGURE 2. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET BASE SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL D. INSTALL 2X AN3C11A BOLT, 2X NAS1149C0332R WASHER & 2X MS21043-3 NUT AS SHOWN IN VIEW H-H. INSTALL THE ROD END OF THE D3969-1 GAS SPRING ONTO THE D3953-3 GAS SPRING STUD USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432R WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW H-H. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.
- 5) INSERT THE D3953-3 GAS SPRING STUD INTO THE D3953-15 GAS SPRING BRACKET & INSERT THE D3953-7 GAS SPRING SPACER ONTO THE D3953-3 GAS SPRING STUD AS SHOWN IN VIEW G-G. RAISE THE BASKET LID AND INSTALL THE D3969-1 GAS SPRING ONTO THE D3953-3 GAS SPRING STUD AND FASTEN IN PLACE USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432R WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW G-G. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.

**NOTE:** THE D3953-3 GAS SPRING STUD CAN BE HELD IN PLACE WITH A  $\frac{9}{16}$  OPEN END SPANNER / WRENCH.

**NOTE:** WITH THE LID IN THE CLOSED POSITION THE GAS SPRING SHOULD NOT BE FULLY COMPRESSED.




- 6) TEST THE INSTALLATION. IF INSTALLED PROPERLY THE GAS SPRING SHOULD ASSIST THE BASKET USER IN BOTH OPENING AND CLOSING THE BASKET LID.

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| MFG. APPR. | N/A   | DSI 9473  | SHEET 3 OF 8 |
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FOR D350-607-045 BASKETS REPLACE THE EXISTING D2332-041 PROP ARM ASSEMBLY AS FOLLOWS:

### **D350-607-145 AUTOMATIC LID OPENER INSTALLATION**

**NOTE:** THIS KIT MAY BE INSTALLED AT EITHER END OF THE BASKET. HOWEVER, THE PROP ARM MUST BE REMOVED IN EITHER CASE AS IT WILL INTERFERE WITH THE FUNCTION OF THE GAS SPRING.

- 1) REMOVE THE D2332-041 PROP ARM.
  - 2) GRIND FLUSH THE D2327-3 SPACER BUSHING ON THE END OF THE BASKET WHERE THE LID OPENER IS BE INSTALLED AS SHOWN IN FIGURE 1 (IT IS PERMISSIBLE TO GRIND ALL 4 SPACERS FLUSH). TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4.
  - 3) LOCATE THE D3953-1 GAS SPRING BRACKET AS SHOWN IN FIGURE 1. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET LID SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL A. INSTALL THE D3953-1 GAS SPRING BRACKET & D3953-13 GAS SPRING SPACER USING 2X AN3C16A BOLT, 2X NAS1149C0332R WASHER & 2X MS21043-3 NUT AS SHOWN IN VIEW E-E.
  - 4) LOCATE THE D3953-5 GAS SPRING STUD AS SHOWN IN FIGURE 1. TRIM STEEL MESH LOCALLY AS REQUIRED. TOUCH UP PAINT PER ICA-D350-607 REV. 0 SECTION 5.1 ITEM 4. TRANSFER MARK AND DRILL 2X Ø0.194 HOLES THRU THE BASKET BASE SQUARE TUBE STRUCTURE AS SHOWN IN DETAIL B. FASTEN D3953-5 IAW VIEW F-F USING 2X AN3C11A BOLT, 2X NAS1149C0332R WASHER & 2X MS21043-3 NUT.
  - 5) INSTALL 1X D3953-11 GAS SPRING SPACER ONTO THE D3953-5 STUD AS SHOWN IN VIEW F-F. INSTALL THE LARGE END OF THE D3969-1 GAS SPRING SPRING ONTO THE D3953-5 GAS SPRING STUD AND FASTEN IN PLACE USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432R WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW F-F. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.
  - 6) INSERT THE D3953-3 GAS SPRING STUD INTO THE D3953-1 GAS SPRING BRACKET & INSERT THE D3953-7 GAS SPRING SPACER ONTO THE D3953-3 GAS SPRING AS SHOWN IN VIEW E-E. RAISE THE BASKET LID AND INSTALL THE ROD END OF THE D3969-1 GAS SPRING ONTO THE D3953-3 GAS SPRING STUD USING 1X D3953-9 GAS SPRING WASHER, 1X NAS1149C0432R WASHER, 1X AN310-4 CASTELATTED NUT & 1X MS24665-212 COTTER PIN AS SHOWN IN VIEW E-E. INSTALL COTTER PIN PER MS33540 OR AC43.13 CHAPTER 7-127.
- NOTE:** THE D3953-3 GAS SPRING STUD CAN BE HELD IN PLACE WITH A  $\frac{9}{16}$  OPEN END SPANNER / WRENCH.

**NOTE:** WITH THE LID IN THE CLOSED POSITION THE GAS SPRING SHOULD NOT BE FULLY COMPRESSED.




- 7) TEST THE INSTALLATION. IF INSTALLED PROPERLY THE GAS SPRING SHOULD ASSIST THE BASKET USER IN BOTH OPENING AND CLOSING THE BASKET LID.

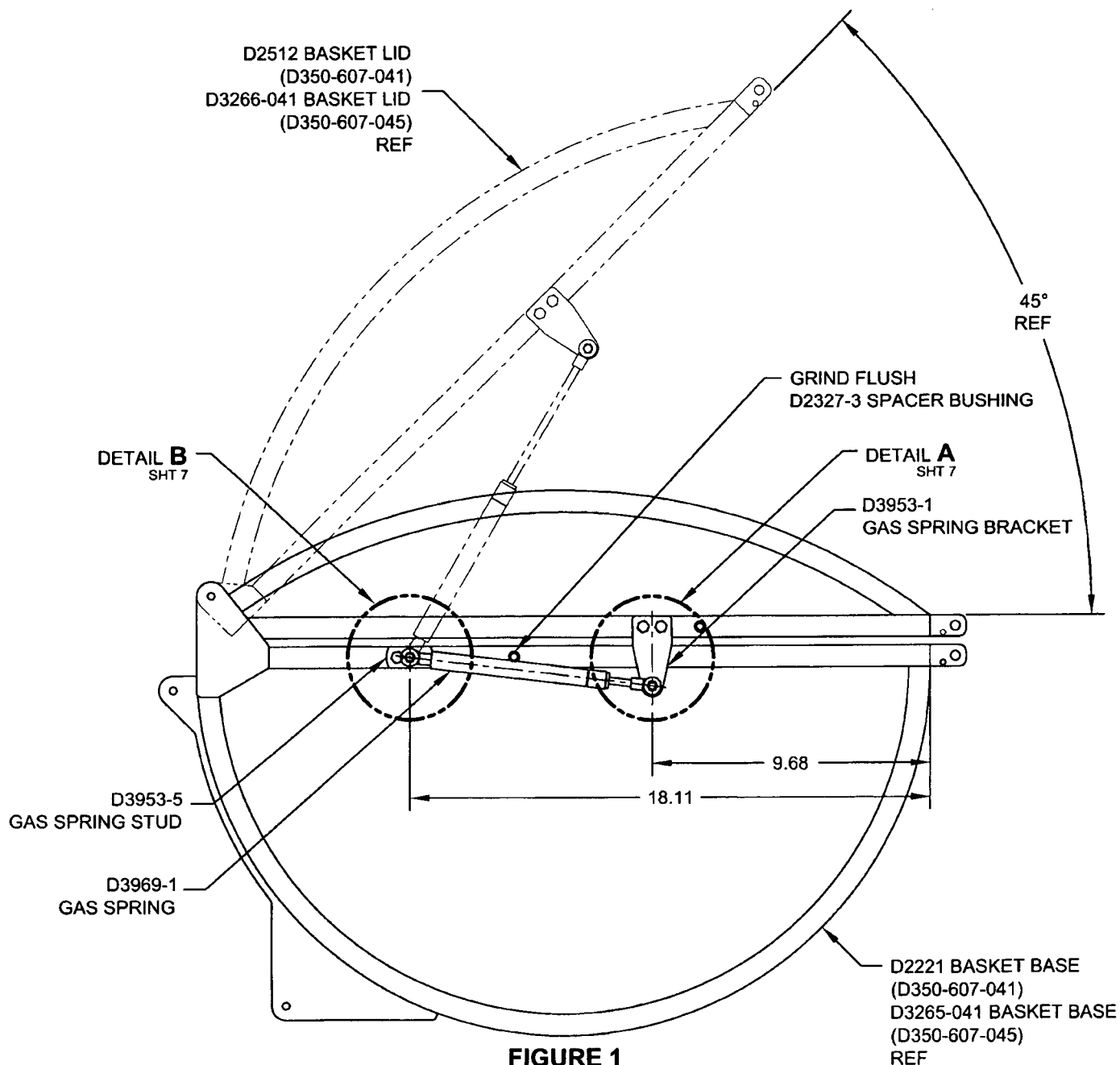
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**FIGURE 1**

**D350-607-141 AUTOMATIC LID OPENER INSTALLATION**  
(BOTH ENDS)

**D350-607-145 AUTOMATIC LID OPENER INSTALLATION**  
(1 END ONLY)

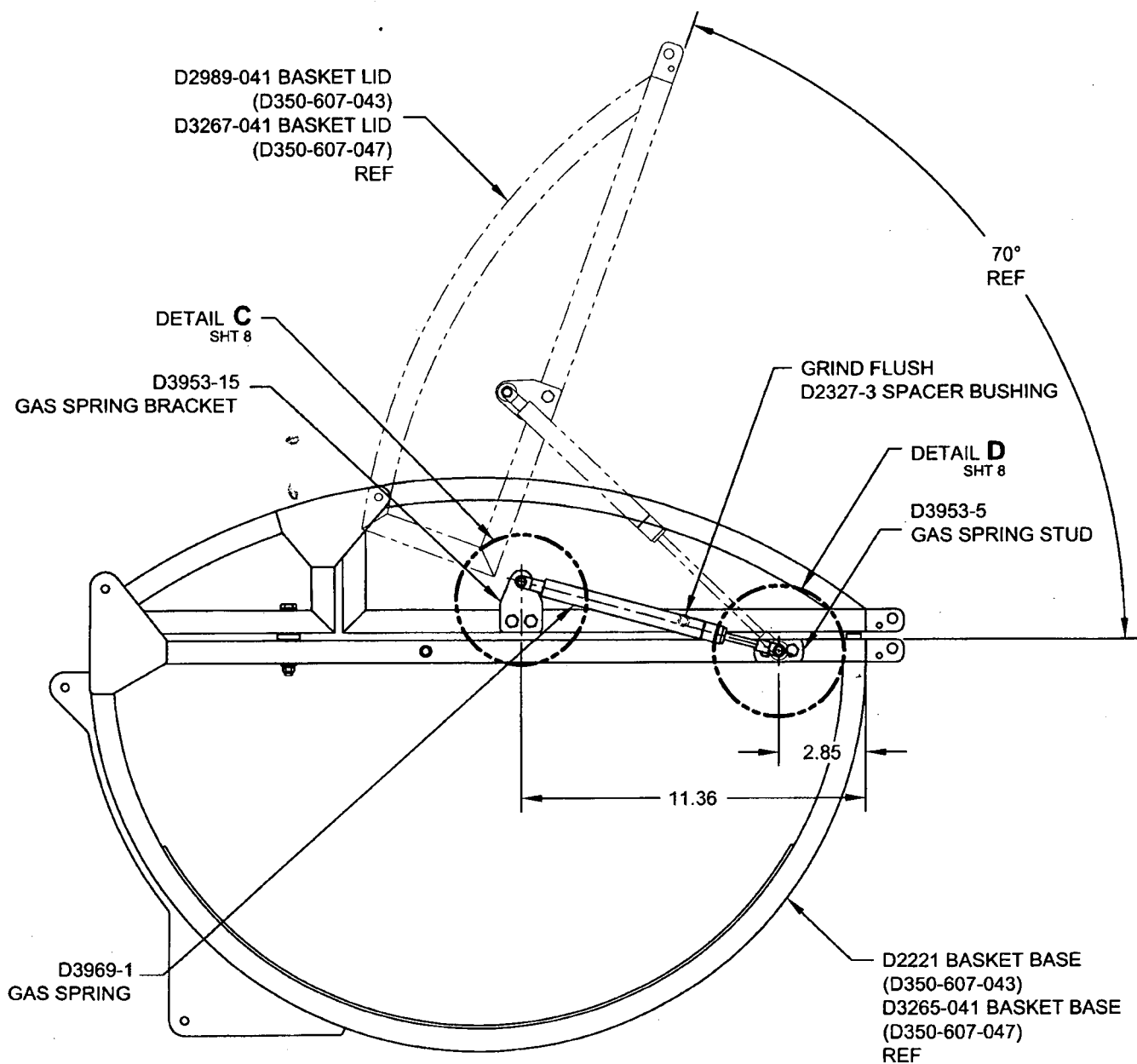
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**FIGURE 2**  
**D350-607-143 AUTOMATIC LID OPENER INSTALLATION**  
 (1 END ONLY)

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| MFG. APPR. | N/A                | DSI 9473  | SHEET 6 OF 8 |
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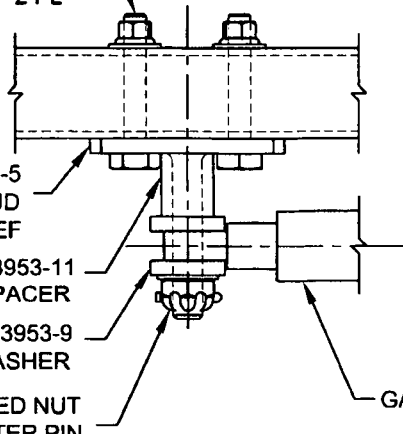
AN3C11A BOLT  
NAS1149C0332R WASHER  
MS21043-3 NUT  
2 PL

D3953-5  
GAS SPRING STUD  
REF

D3953-11  
GAS SPRING SPACER

D3953-9  
GAS SPRING WASHER

AN310-4 CASTELLATED NUT  
MS24665-212 COTTER PIN  
NAS1149C0432R WASHER



**VIEW F-F**

AN3C16A BOLT  
NAS1149C0332R WASHER  
MS21043-3 NUT  
2 PL

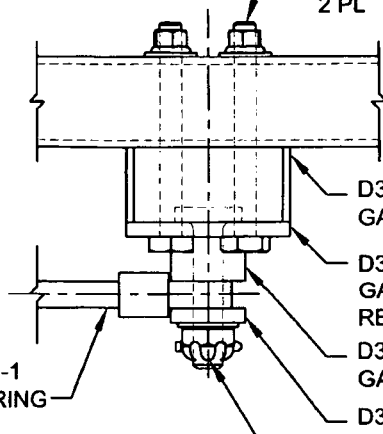
D3953-13  
GAS SPRING SPACER

D3953-1  
GAS SPRING BRACKET  
REF

D3953-7  
GAS SPRING SPACER

D3953-9  
GAS SPRING WASHER

D3953-3 GAS SPRING STUD  
AN310-4 CASTELLATED NUT  
MS24665-212 COTTER PIN  
NAS1149C0432R WASHER

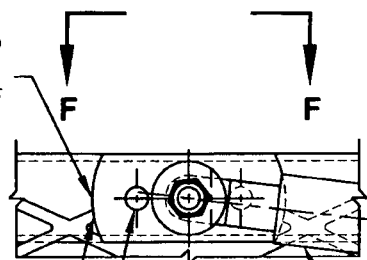


**VIEW E-E**

D3953-5  
GAS SPRING STUD  
REF

TRIM MESH LOCALLY  
AS REQUIRED

TRANSFER MARK AND  
DRILL Ø0.194 THRU  
2 PL

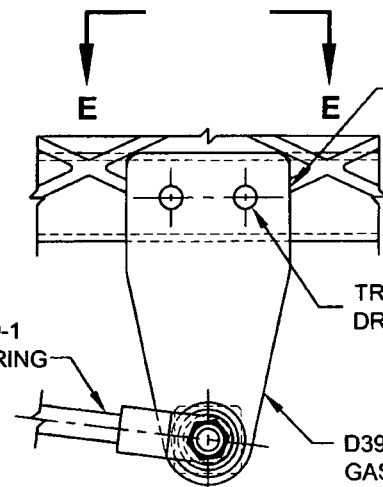


**DETAIL B**

TRIM MESH LOCALLY  
AS REQUIRED

TRANSFER MARK AND  
DRILL Ø0.194 THRU

D3953-1  
GAS SPRING BRACKET  
REF






**DETAIL A**

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AN3C15A BOLT  
NAS1149C0332R WASHER  
MS21043-3 NUT  
2 PL

D3953-17  
GAS SPRING SPACER

D3953-15  
GAS SPRING BRACKET  
REF

D3953-7  
GAS SPRING SPACER

D3953-9  
GAS SPRING WASHER

D3953-3 GAS SPRING STUD  
AN310-4 CASTELLATED NUT  
MS24665-212 COTTER PIN  
NAS1149C0432R WASHER

**VIEW G-G**

AN3C11A BOLT  
NAS1149C0332R WASHER  
MS21043-3 NUT  
2 PL

D3953-5  
GAS SPRING STUD  
REF

D3953-11  
GAS SPRING SPACER

D3953-9  
GAS SPRING WASHER

AN310-4 CASTELLATED NUT  
MS24665-212 COTTER PIN  
NAS1149C0432R WASHER

D3969-1  
GAS SPRING  
REF

**VIEW H-H**

G G

D3953-15  
GAS SPRING BRACKET  
REF

TRANSFER MARK AND  
DRILL Ø0.194 THRU

TRIM MESH LOCALLY  
AS REQUIRED

D3969-1  
GAS SPRING  
REF

**DETAIL C**

H H

D3953-5  
GAS SPRING STUD  
REF

TRIM MESH LOCALLY  
AS REQUIRED

TRANSFER MARK AND  
DRILL Ø0.194 THRU

**DETAIL D**

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